



Service Repair Manual

Models

D11R Track-Type Tractor

Product: TRACK-TYPE TRACTOR

Model: D11R TRACK-TYPE TRACTOR 9TR

Configuration: D11R Track-Type Tractor 9TR00001-UP (MACHINE) POWERED BY 3508 Engine

Disassembly and Assembly

3500 and 3500B High Displacement Engines for Caterpillar Built Machines

Media Number -SEN1126-33

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i06795257

Cylinder Head - Assemble

SMCS - 1100-016

Assembly Procedure

Valve Lifters

NOTICE

Keep all parts clean from contaminants.

Contaminants may cause rapid wear and shortened component life.



Illustration 1

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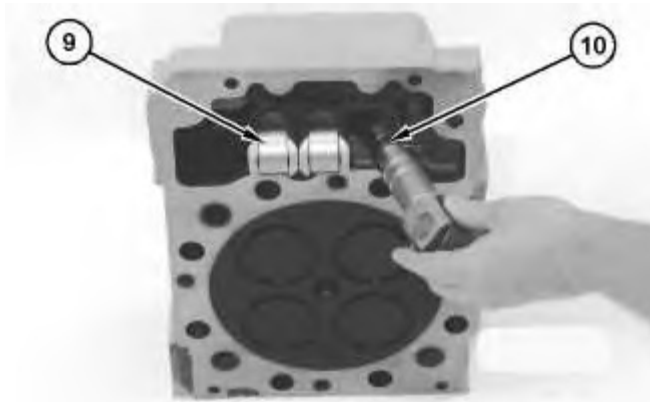


Illustration 2

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! WARNING

Improper assembly of parts that are spring loaded can cause bodily injury.

To prevent possible injury, follow the established assembly procedure and wear protective equipment.

Note: Install the lifter assembly into the cylinder head. Ensure that the word "LEFT" stamped on end of the bronze pin is always oriented to the LEFT as viewed from the side of the engine regardless of left side or right side bank. Immerse the lifter assembly in engine oil before assembled in the cylinder head lifter bore.

1. Install new guide spring (10) for valve lifter (9).
2. Place valve lifter (9) in a container of clean engine oil prior to installation.
3. Install valve lifter (9) into the cylinder head.

Note: Refer to Specifications, "Valve Mechanism".

Inlet and Exhaust Valve Guides

Table 1

Required Tools			
Tool	Part Number	Part Description	Qty
E	7M-3975	Valve Guide Driver	1
	5P-1729	Valve Guide Bushing	1

NOTICE

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Note: Use new valve guides for assembly.

1. Coat the outside of the valve guides with clean engine oil prior to installation.
2. Use Tooling (E) and a suitable press to install the valve guides. The valve guide must extend 26.0 ± 0.50 mm (1.02 ± 0.020 inch) above the surface of the cylinder head.

Inlet and Exhaust Valve Seat Inserts

Table 2

Required Tools			
Tool	Part Number	Part Description	Qty
F	1P-0510	Driver Gp	1

NOTICE

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Note: Use new inserts for assembly.

1. Lower the temperature of the valve seat inserts. Install the valve seat inserts with Tooling (F).

Bridge Dowels

Table 3

Required Tools			
Tool	Part Number	Part Description	Qty
G	6V-4009	Dowel Driver	1

NOTICE

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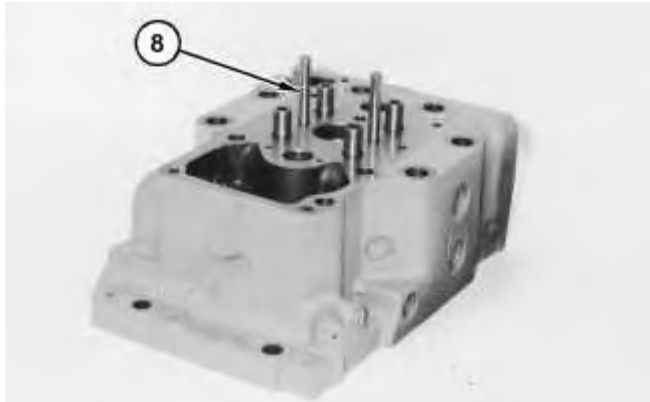


Illustration 3

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Note: Use new dowels for assembly. Refer to Service Magazine, SEPD1825, "New Cylinder Head Groups and Valve Mechanisms" for the correct procedure.

1. Use Tooling (G) with a hammer to install bridge dowels (8). The bridge dowels must extend 66.5 ± 0.50 mm (2.62 ± 0.020 inch) above the surface of the cylinder head.

Inlet and Exhaust Valves

Table 4

Required Tools			
Tool	Part Number	Part Description	Qty
A	5S-1330	Valve Spring Compressor	1

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